

ASAP

Date: Thursday, 4/26/2007 7:48:17 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD
Job Number	32071			
Estimate Number	12711			
P.O. Number	N/A		Part Number	D35373
This Issue	4/26/2007	S.O. No. : N/A	Drawing Number	D3537 UNDER REVIEW
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A		Drawing Revision	X PH 07.04.26
Previous Run	31726		Material	C RT 07.05.23
Written By			Due Date	5/3/2007 Qty: 20 Um: Each
Checked & Approved By				28/05
Comment	Est Rev:A New Issue 07-02-14 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		25213
		Comment: Qty.: 0.1512 sf(s)/Unit Total : 3.0240 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: m101873 ml 07 04 26
2.0	WATER JET	FLOW WATER JET
		15
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: BC ml 07 04 26 Prog Rev: BC
		10
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		20/25
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Parts were found @ the water Jet 07-05-23
		20/25
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158
		10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-23	2.0	5pm As done to old Rev. No good.	SJ	Scraps & destroy. Qty 10 @ New Dmg Rev. C.	SJ 07/05/23	J	J	J

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 32071

Part Number: D35373

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

10 07-06-01 10

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	m102956
Weld hardcoat as per Dwg D3437		

FC 07/06/04 10

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10 07-06-04 10

10.0 POWDER COATING

POWDER COATING



m 101601

10

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/FX.

07-06-04

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m-1

07/06/04

10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1

PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: EP-18

m-1 07/06/04

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



A. Johnston

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

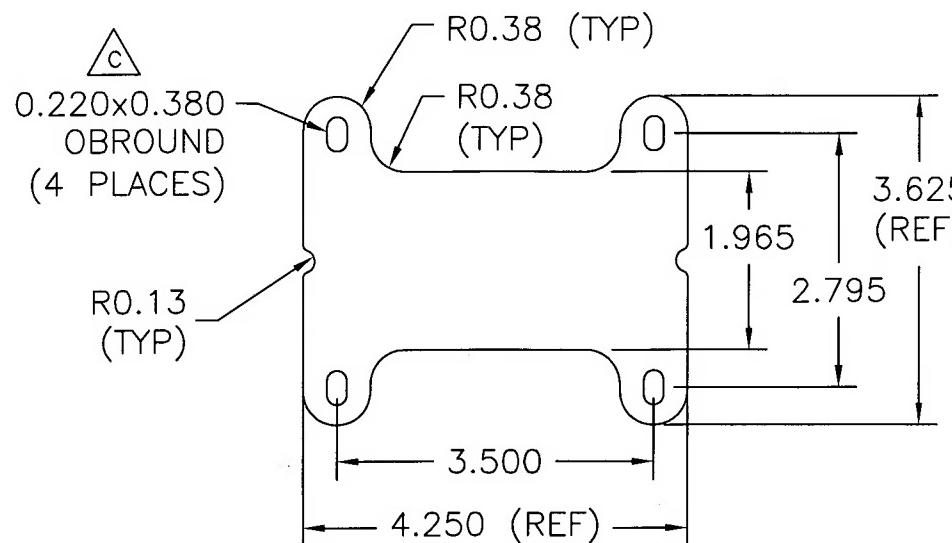
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

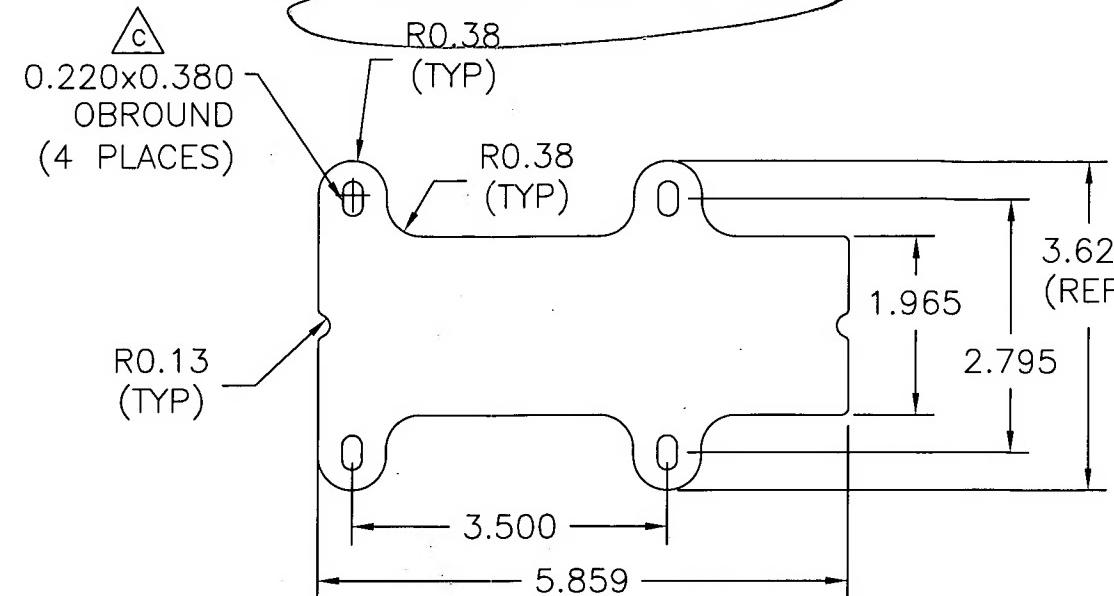
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

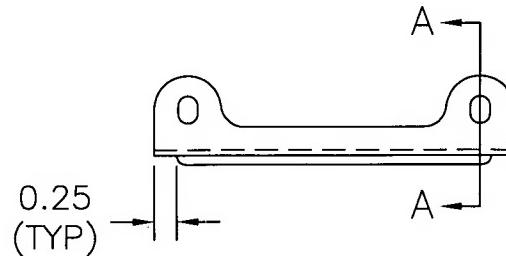
D3537-1F FLAT PATTERN



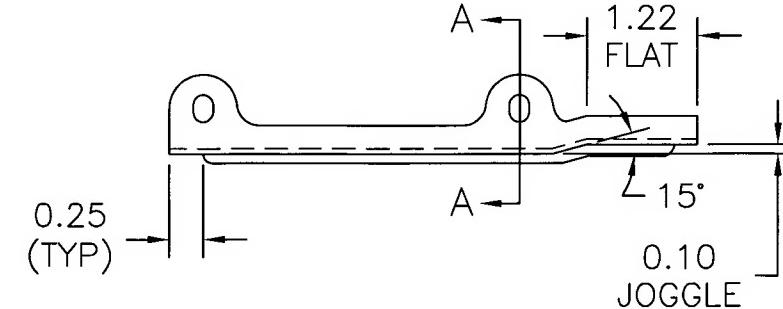
D3537-3F FLAT PATTERN



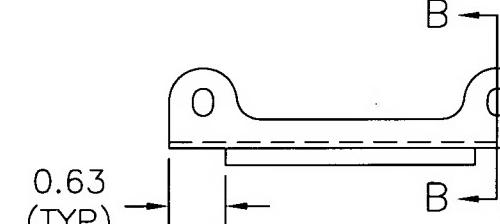
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



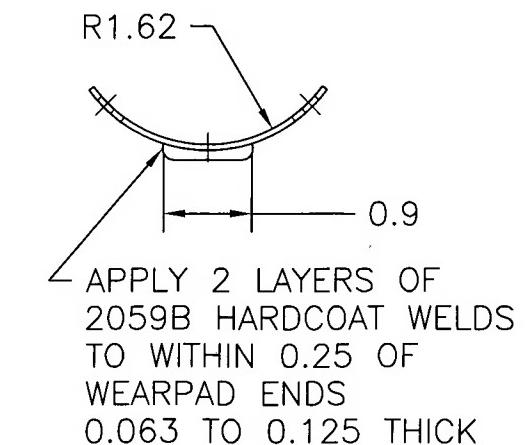
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

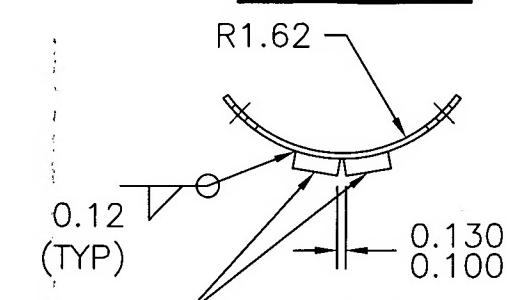
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SECTION A-A

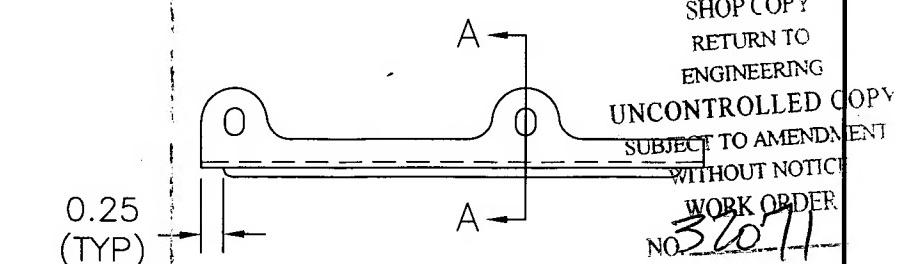


SECTION B-B



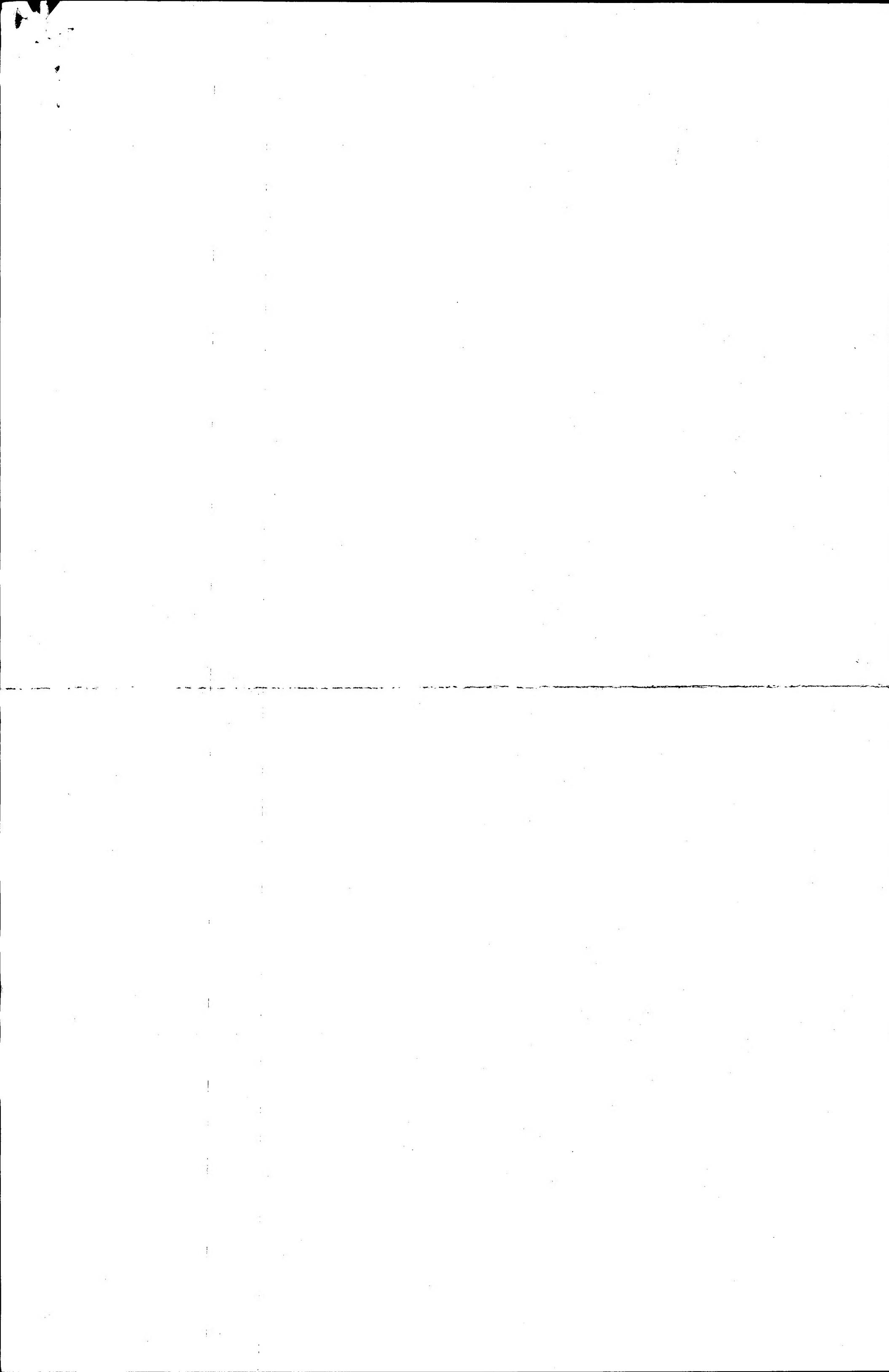
PRELIMINARY ISSUE

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36071

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. D3537
DATE		TITLE WEARPAD
07.04.13		SCALE 1:2



DART AEROSPACE LTD

Work Order: 32071

Description: Wearpad

Part Number: D3537-3

Inspection Dwg: D3537 Rev: B C PH 07.06.05

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.625	+/- 0.010	3.624	✓		VERN	
B 2.795	+/- 0.010	2.795	✓		VERN	
C 1.965	+/- 0.010	1.968	✓		VERN	
D 3.500	+/- 0.010	3.504	✓		VERN	
E 5.859	+/- 0.010	5.866	✓		VERN	
F 0.220 X 0.380	+/- 0.010	0.217 X 0.380	✓		VERN	
G						
H						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: *[Signature]*
Date: 07/04/26Audited by: *[Signature]*
Date: 07/05/23Prototype Approval: NA
Date: NA

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	